

Rustt

Dart Aerospace Ltd.

Date: Thursday, 06/11/2008 12:52:34 PM
 User: Chantal Lavoie

Process Sheet

Split

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : COVER
 Job Number : 43233-2
 Estimate Number : 12963
 P.O. Number :
 This Issue : 06/11/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : SMALL / MED FAB
 Previous Run : 34544
 Part Number : D36414
 Drawing Number : D3641 REV B
 Project Number : N/A
 Drawing Revision : B
 Material :
 Due Date : 13/11/2008 Qty: 3 Um: 15 Each
 Written By :
 Checked & Approved By :
 Comment : Est Rev:A New Issue 07-07-20 JLM Verified By:EC
 Est Rev:B ECN 1050 rev.b as per dwg 08-01-10 DD

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6S032 6061-T6 Sheet 0.032"



.040



Comment: Qty.: 0.8244 sf(s)/Unit Total : 12.3653 sf(s) MAT NOT PULLED
 M6061-T6 .032" THK sheet
 Batch: 109396 IB 8-11-7 16954

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
 1-Cut as per Dwg D3641
 Dwg Rev: B
 Prog Rev: B

IB 8-11-7

(17)

2-Deburr if necessary IB 8-11-7

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

208-11-07 (17)

(PTU)

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE
 Form as per Dwg D3641-1

208/11/07 (3)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: COVER

Job Number: 43233

Part Number: D36414

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

8/5 08/11/07 (3)

7.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Fol 08/11/07 (3)

8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8/11/7

(3x)

9.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock

Location: 024

8/11/7

(3x)

511

10.0	QC21	FINAL INSPECTION/W/O RELEASE
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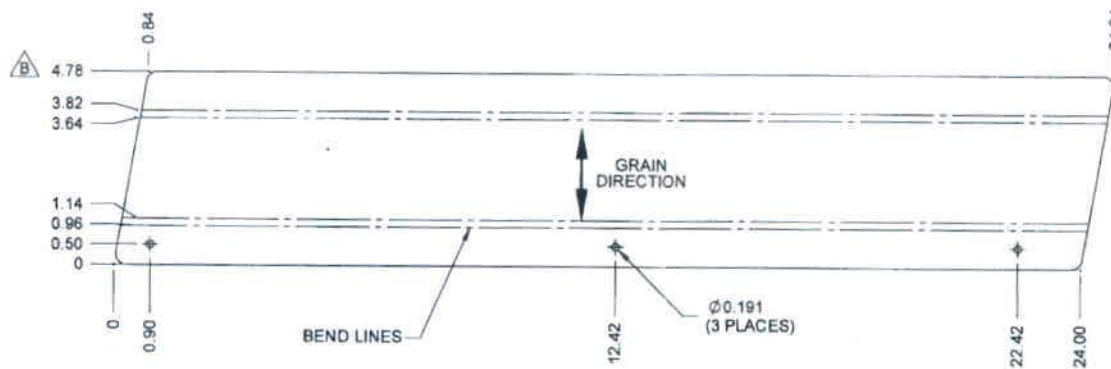
Comment: FINAL INSPECTION/W/O RELEASE

08/11/10

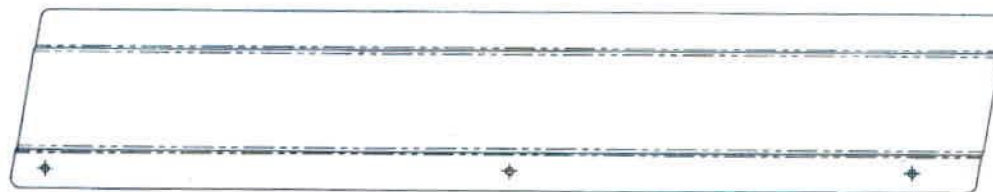
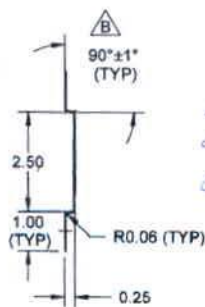
Job Completion



mf 08-11-10



D3641-3F FLAT PATTERN



W/O: 43233
C/L 8/11/06

D3641-3 COVER
(REPLACES GENEVA P/N G10606-5)
D3641-4 OPPOSITE
(REPLACES GENEVA P/N G10606-4)

W/O 43233

RELEASED
07.11.17

NOTES:

- 1) MATERIAL: 5052-H32 ALUMINUM 0.032 THICK PER QQ-A-250/8 OR AMS 4016 (REF DART SPEC M5052H32S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3641-3/-4" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.36 lbs

DESIGN	TS	DART AEROSPACE USA, INC.	
DRAWN	LE	PORT HADLOCK, WA	
CHECKED	PM	DRAWING NO.	REV. B
MFG APPR.	IS	D3641	SHEET 2 OF 2
APPROVED	W	TITLE	SCALE
DE APPR.	W	COVER	1:3
DATE	07.10.16	COPYRIGHT © 2007 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT PERMISSION FROM DART AEROSPACE USA, INC.	

